

Work Order ID 52317

Tuesday, September 22, 2009 2:51:52 PM



Page 2

Item ID: D3407-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Stem

Start Date: 9/23/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: SAL

0.00



Packaging

Memo

0.00

Packaging

09/19/28 (30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/28
09-9-28

Picklist Print

Tuesday, September 22, 2009 2:51:52 PM

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Work Order ID: 52317



Parent Item: D3407-1RevE



Parent Item Name: Stem



Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174R0.750		Purchased	No			100	f	38.5450	11.5579			
												
17-4 round bar .750												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

38.545

110777

12.25

111642

26.295

13.725

DART AEROSPACE LTD		Work Order: 52317
Description: Tow Ring		Part Number: D3407-1
Inspection Dwg: D3407 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/			
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/			
Major Ø	Max: 0.249 Min: 0.2425	.245	/			
Ø0.625	+/-0.010	.625	/			
Ø0.363	+/-0.010	.363	/			
Ø0.750	+/-0.010	.750	/			
R0.100	+/-0.010	R.100	/			
0.470	+/-0.010	.470	/			
0.500	+/-0.010	.500	/			
3.250	+/-0.010	3.250	/			
4.250	+0.000/-0.010	4.25	/			
5.270	+/-0.010	5.270	/			
0.150	+/-0.010	.150	/			
0.550	+/-0.010	.550	/			
0.625	+/-0.010	.625	/			
0.250	+0.010/-0.000	.251	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09.09.24	Date: 09/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

SHOP COPY

RETURN TO

ENGINEERING

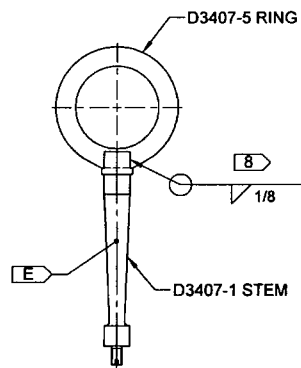
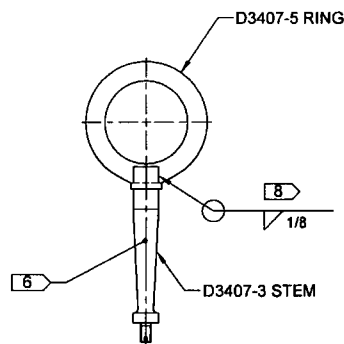
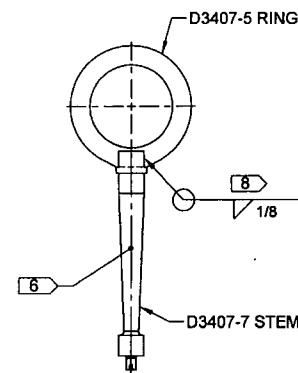
UNCONTROLLED

SUBJECT TO APPROVAL

WORK ORDER

52317

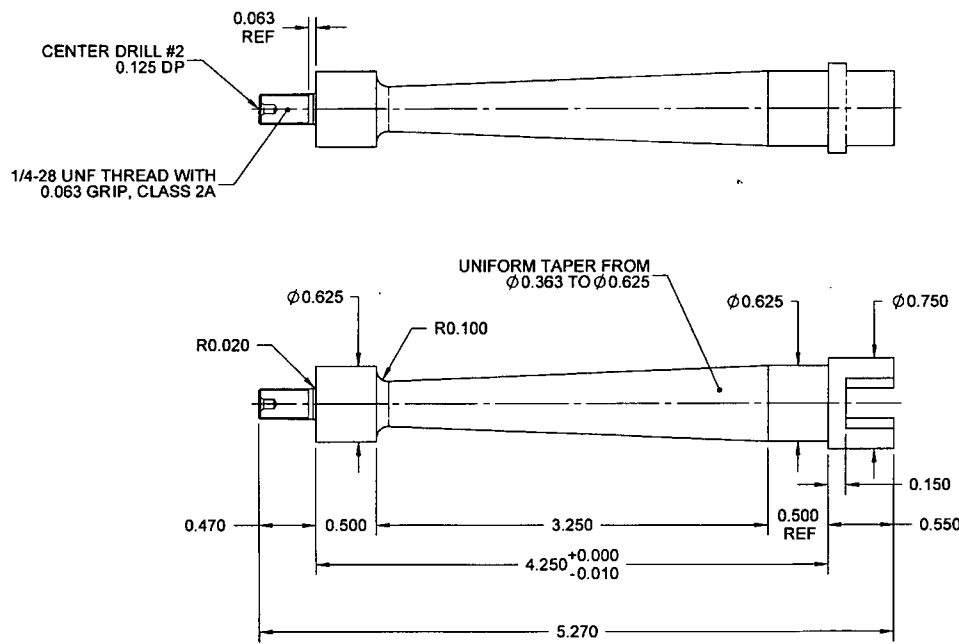
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

**D3407-041 TOW RING****D3407-043 TOW RING****D3407-045 TOW RING****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, WA		
CHECKED			
MFG. APPR.	DRAWING NO. D3407	REV. E	
APPROVED	TITLE TOW RING	SHEET 1 OF 5	
DE APPR.		SCALE	
DATE	08.07.23	NTS	
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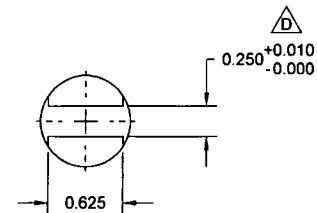
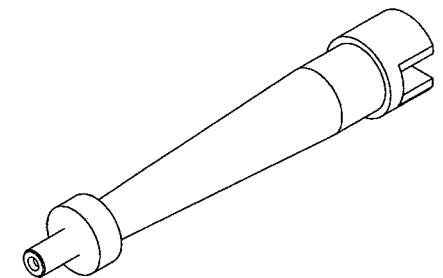
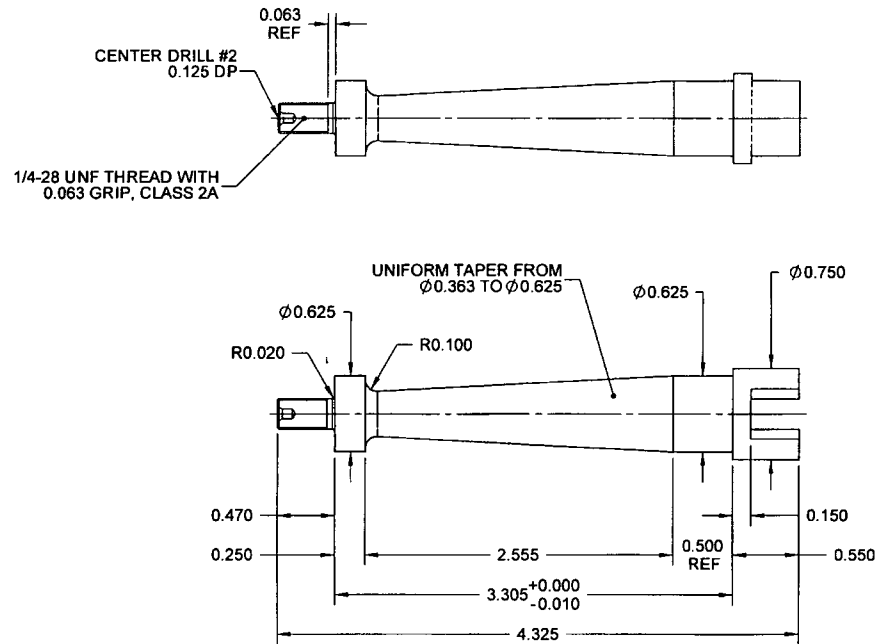
[D3407-1 STEM]

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

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MFG. APPR.	<i>JP</i>	D3407	SHEET 2 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	TOW RING	NTS
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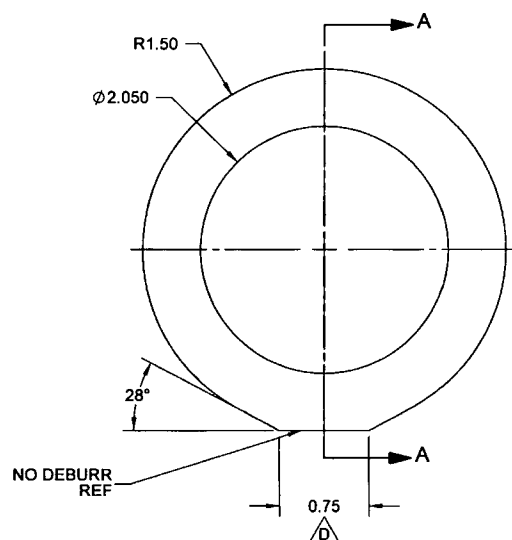
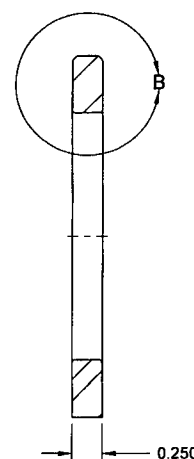
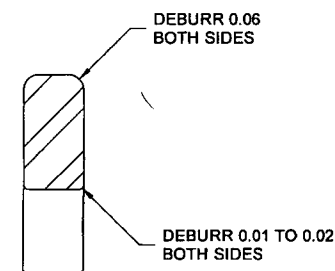
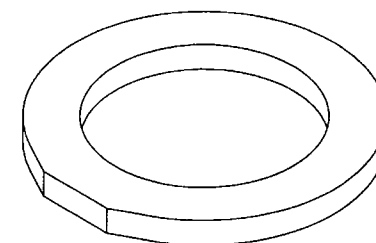
D3407-3 STEM

RELEASED

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 3 OF 5
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DE APPR.		TOW RING	NTS
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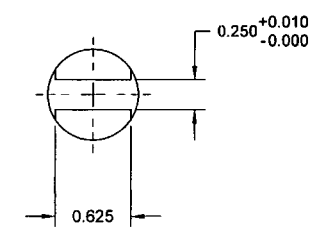
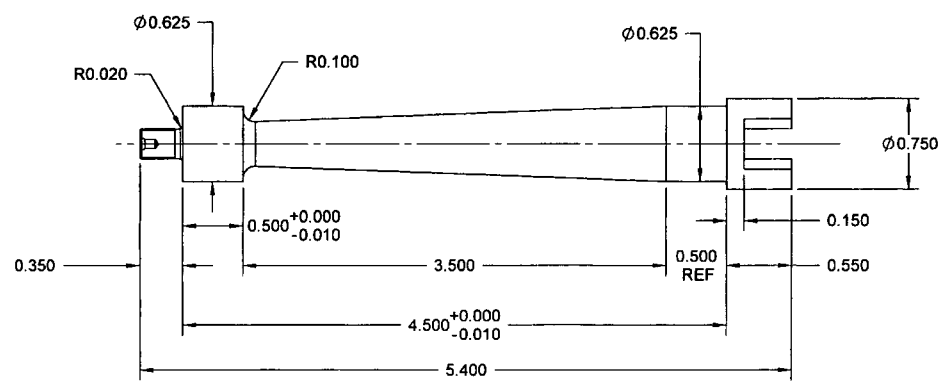
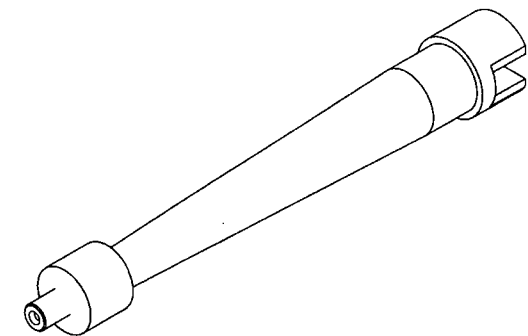
**D3407-5 RING****SECTION A-A****DETAIL B
SCALE 2X****RELEASED**
01-08-01-11-11**NOTES:**

- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

DESIGN	97	DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 4 OF 5
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52317

8 7 6 5 4 3 2 1



D3407-7 STEM

RELEASED

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 5 OF 5
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8 7 6 5 4 3 2 1